

# Work Order ID 61726

Tuesday, August 31, 2010 2:41:56 PM



Page 1

Item ID:	D2804-041	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Bracket Assembly					
Start Date:	8/31/2010	Start Qty:	2.00			
Required Date:	9/7/2010	Req'd Qty:	2.00			
Reference:						
				Cust Item ID:		
				Customer:		

Approvals:	Process Plan:	<u>H</u>	Date:	<u>10-8-31</u>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2804	Rev C								

100  
 Small Fab 0.00  
 Small Fab Memo 0.00  
 Small Fab Press D2805-1 Into arm as per Dwg D2804

8/31/10 11 (2)

110  
 QC5- Inspect part completeness to step on W/O 0.00  
 QC Memo 0.00  
 Quality Control

8/31/10

x4  
-041

120  
 White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum 0.00  
 Powdercoat Memo 0.00  
 Powder Coating

M 115951

START TIME: 9:00 ☐ OVEN TEMPERATURE:  
 FINISH TIME: 9:30

H BR 11-01-13.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**Work Order ID 61726**



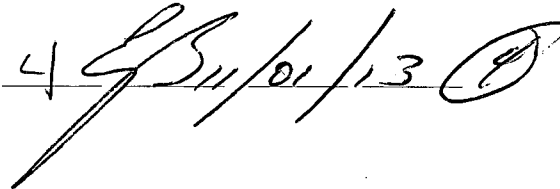

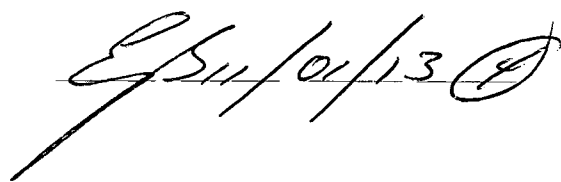
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Page 2

Item ID: D2804-041 Accept  Setup Start   
Revision ID: Stop   
Item Name: Bracket Assembly  
Start Date: 8/31/2010 Start Qty: 2.00  Cust Item ID:  
Required Date: 9/7/2010 Req'd Qty: 2.00  Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start   
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  QC Quality Control	QC3- Inspect Part Finish  Memo	0.00  0.00				<u>H.</u>	<u>HL</u>	<u>11/6/11/12</u>	
140  Small Fab Small Fab	Small Fab  Memo Press D2809 into arm as per Dwg D2804	0.00  0.00							<u>4</u> <u>EB</u> <u>11/01/13</u> 
150  Small Fab Small Fab	Small Fab  Memo 1-Spray LPS-3 on Bolt Shaft, not on thread as per Dwg D2804 <input type="checkbox"/> 2-Assemble as per Dwg D2804.	0.00  0.00							<u>EB</u> <u>11/01/13</u> 

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			



**NOTE:** Date & initial all entries


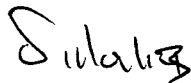

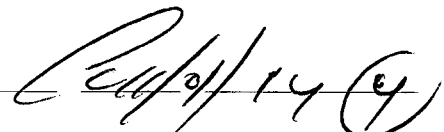

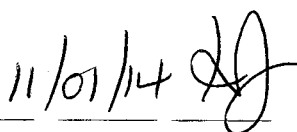
**Work Order ID 61726**


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Item ID: D2804-041 Accept  Setup Start   
Revision ID:  
Item Name: Bracket Assembly Stop   
Start Date: 8/31/2010 Start Qty: 2.00  Cust Item ID:  
Required Date: 9/7/2010 Req'd Qty: 2.00  Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start   
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160  QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00 0.00							
170  Packaging Packaging	Identify as per dwg & Stock Location: <u>150</u>  Memo	0.00 0.00							
180  QC Quality Control	QC21- Final Inspection - Work Order Release  Memo	0.00 0.00							

11/01/14 

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Page 1

Work Order ID: 61726

Parent Item: D2804-041

Parent Item Name: Bracket Assembly

Start Date: 8/31/2010

Required Date: 9/7/2010

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP F05.03.30 MS21043-3 was MS21042L3 KJ/JLM  
IPP Rev:G As per Rev C 06-11-08 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D2804-1		Manufactured	No			100	Each	0.0000	1	2			
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Bracket

D2805-1



Stop

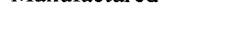
B62054

~~B62054~~ (4K)



ES 11/01/11  
~~ES 10/12/10~~

D2805-1		Manufactured	No			100	Each	12.0000	1	2			
---------	--	--------------	----	--	--	-----	------	---------	---	---	--	--	--



ES 11/01/11  
~~ES 10/12/10~~

Location

Loc Qty

Loc Code

ST024

12

46735

2

58527

10

B62247 (4K)

~~B62247~~ (4K)

NAS1515H3



Washer

NAS1515H3		Purchased	No			100	Each	90.0000	4	8			
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Location

Loc Qty

Loc Code

ST277

90

111268

90

ES 10/01/13

M115935 (160)

AN3C16A



Bolt

AN3C16A		Purchased	No			150	Each	75.0000	2	4			
---------	--	-----------	----	--	--	-----	------	---------	---	---	--	--	--

Location

Loc Qty

Loc Code

ST352

75

111193

25

111425

50

ES 11/01/13

M115835 (20)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries



# Picklist Print

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Page 2

Work Order ID: 61726

Parent Item: D2804-041

Parent Item Name: Bracket Assembly

Start Date: 8/31/2010

Required Date: 9/7/2010

Start Qty: 2.00

Required Qty: 2.00

D2809

Manufactured No

150

Each

51.0000

1

2



Bushing



*EP 11/01/13*

Location

Loc Qty

Loc Code

ST025

51

34035

12

46438

1

47733

~~25~~ 8

*4*

MS21043-3

Purchased No

150

Each

2,733.000

2

4



Nut



*EP 11/01/13*

Location

Loc Qty

Loc Code

FG

76

103691

76

ST301

2657

109147

49

111383

46

112314

2562

*8*

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

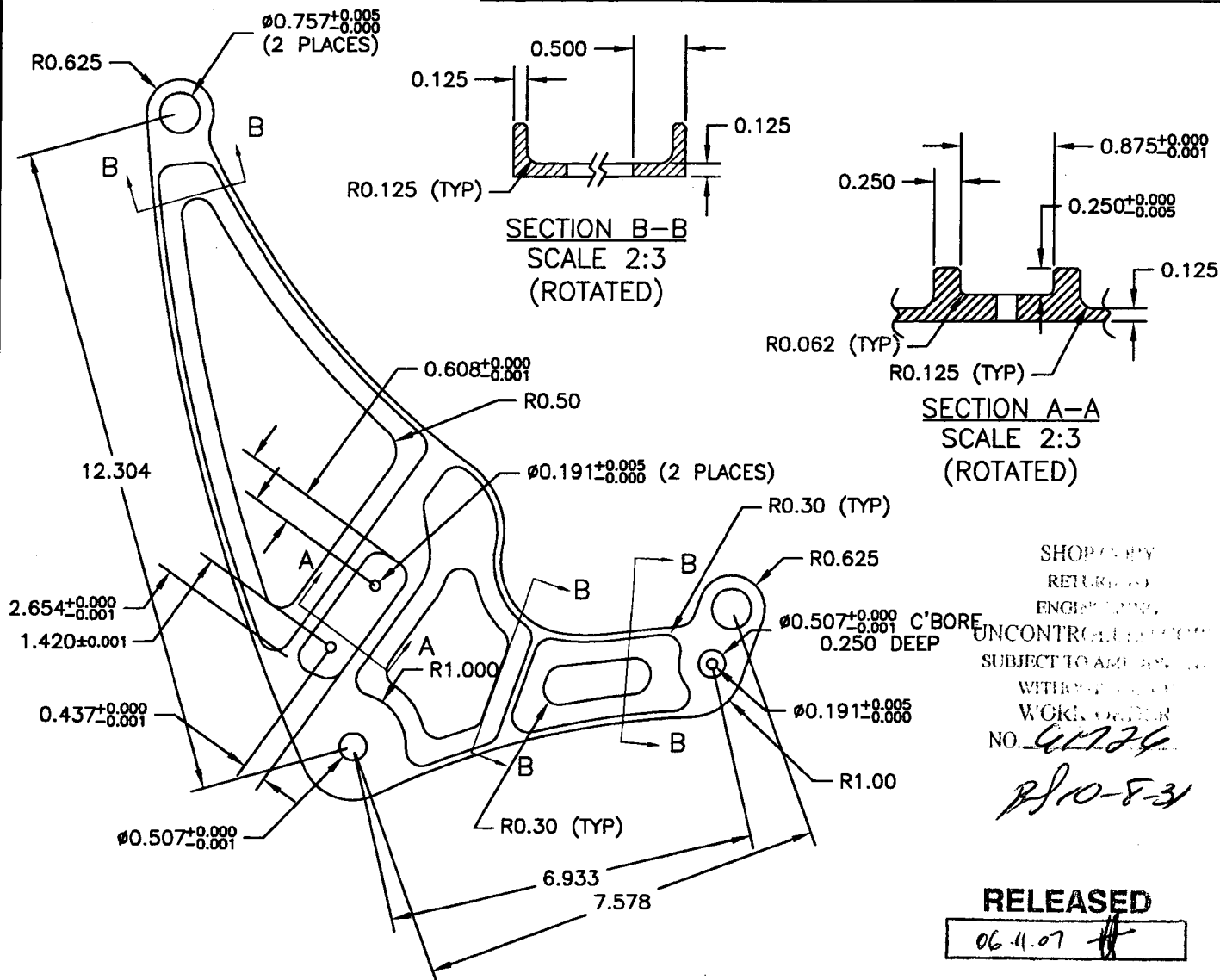
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**DART**

DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD
				HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO. D2804
				REV. C SHEET 1 OF 2
DATE	06.10.16	TITLE	STA 155 BRACKET	SCALE 1:3
A	00.11.07	NEW ISSUE		
B	04.11.22	ADD CUTOUTS & -043/-044		
C	06.10.16	CHANGE GEOM. TO ADD CLEARANCE		



SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO APPROVAL  
WITHIN 14 DAYS  
WORK ORDER  
NO. *41724*

**RELEASED**06-11-07 *[Signature]***D2804-1 BRACKET (SHOWN). D2804-2 BRACKET (OPPOSITE)**

- 1) MACHINE PER DRAWING FILE "D2804-1C.SLDPRT"
- 2) MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK
- 3) DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

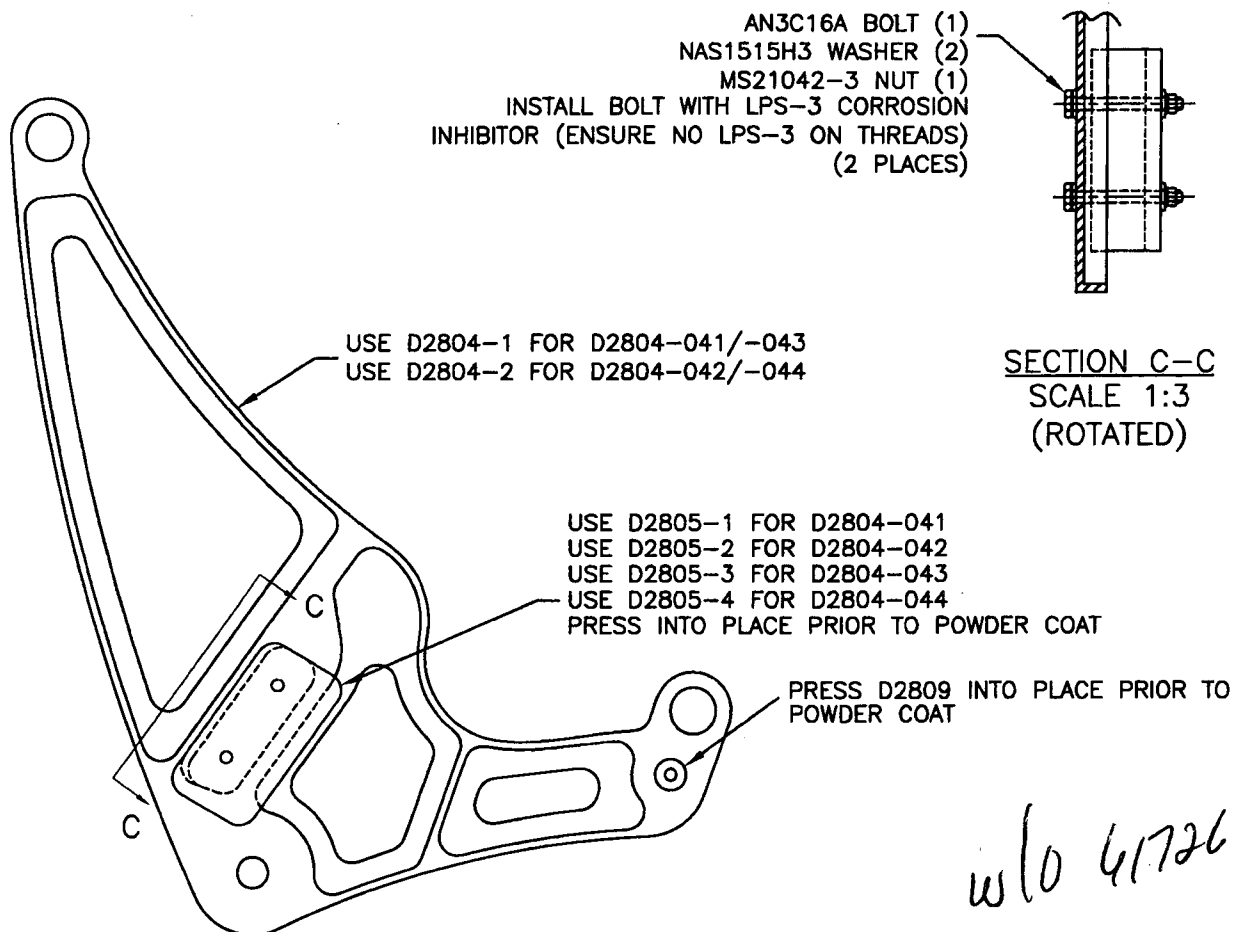
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D2804	REV. C SHEET 2 OF 2
DATE 06.10.16		TITLE STA 155 BRACKET	SCALE 1:3



RELEASED

06.11.07

**D2804-041/-043 BRACKET ASS'Y (SHOWN).**  
**D2804-042/-044 BRACKET ASS'Y (OPPOSITE)**

6) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6)  
OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3

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# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries